

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001557**Date Inspected:** 27-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** n/a**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 Meter Mock-Up/Plate Material Verification**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Tower Shop**89 Meter Mock-Up**

QA Inspector Brannon observed ZPMC personnel are continuing with manual drilling of the bolt holes at skin plate E for the Shear Link Beam in a skewed position. QA Inspector Brannon was informed by ZPMC Fu Jun that ZPMC has completed ultrasonic testing (UT) on CWR048 for the 89 meter box diagonal stiffener and has accepted the UT results.

Plate Material Storage Yard (production):

QA Inspector Brannon received plate material list for batch #83 production plate list No. 4914~4959 and batch #89 production plate list No. 5128~5185 received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC material storage yard accompanied by ZPMC Quality Assurance Miss. Zhu Weijuan and Mr. Zhong Chuan. Verification of plate material is based on random verification.

Plate Material Storage Yard (check samples):

Quality Assurance (QA) Inspector Brannon received plate material list for Caltrans check test samples, plate list No. 181 & 182 (35th batch), No. 183 & 184 (38th batch), No. 185 (39th batch), No. 186 & 187 (40th batch), No. 188 42nd batch), No. 189 & 190 (43rd batch), No. 191 (45th batch), No. 192, 193, 195, 197, 198 & 199 (46th

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batch) and No. 202 (50th batch) received from American Bridge/Fluor (ABF). QA Inspector Brannon went to the ZPMC plate material storage yard accompanied by ZPMC Quality Control Miss. Zhu Weijuan and Mr. Zhong Chuan. QA Inspector Brannon verified, plate ID #, Grade, Batch # and material test reports. QA Inspector Brannon wrote lot numbers and marked the direction of rolling on each of the 18 samples. Caltrans lot numbers for check samples are as follows.

No. 181, ID#070416Q190, Grade A709M-345F2-X, Heat No.7200322N , MTR No. 1885,
Remarks-SPCM, Lot No. B22-024-08

No. 182, ID#WY070406Q108, Grade A709M-345T2-Z, Heat No. 07101372N, MTR No. 1253,
Remarks-Skin Plate, Lot No. B22-021-08.

No. 183, ID#WY070616Q010, Grade A709M-345F2-X, Heat No. 7301534N, MTR No. 4287,
Remarks-SPCM, Lot No. B22-025-08.

No. 184, ID#WY070616Q019, Grade A709M-345F2-X, Heat No. 7301535N, MTR No. 3322,
Remarks-SPCM, Lot No. B22-026-08.

No. 185, ID#WY070926Q011, Grade A709M-345F2-X, Heat No. 07303600N0, MTR No. 6041,
Remarks-Shell plate, Lot No. B22-022-08.

No. 186, ID#WY070926Q011, Grade A709M-345T2-X-S, Heat No. 07302148N0, MTR No. 6726,
Remarks-Shell plate, Lot No. B22-018-08.

No. 187, ID#WY070926Q011, Grade A709M-345F2-X-S, Heat No. 7301535N, MTR No. 2104,
Remarks-Shell plate. Lot No. B22-017-08.

No. 188, ID#WY070906Q091, Grade A709M-345F2-X, Heat No. 07303572N0, MTR No. 6455,
Remarks-SPCM. Lot No. B22-012-08.

No. 189, ID#WY070526Q137, Grade A709M-345F2-X, Heat No. 7301485N, MTR No. 2502,
Remarks-SPCM. Lot No. B22-016-08.

No. 190, ID#WY070826Q101, Grade A709M-345F2-X, Heat No. 07302138N0, MTR No. 6403,
Remarks-SPCM. Lot No. B22-009-08.

No. 191, ID#WY070726Q273, Grade A709M-345T2-X-S, Heat No. 07302314N0, MTR No. 6756,
Remarks-Shell plate. Lot No. B22-019-08.

No. 192, ID#WY070906Q031, Grade A709M-345F2-X, Heat No.07302174N0 , MTR No. 5302,
Remarks-SPCM, Lot No. B22-023-08

No. 193, ID#WY070836Q257, Grade A709M-345F2-X, Heat No. 07301541N0, MTR No. 5302,
Remarks-SPCM, Lot No. B22-015-08.

No. 195, ID#WY071006Q116, Grade A709M-345F2-X, Heat No. 07303999N1, MTR No. 6397,
Remarks-SPCM, Lot No. B22-020-08.

No. 197, ID#WY071006Q107, Grade A709M-345F2-X, Heat No. 07301542N0, MTR No. 6449,
Remarks-SPCM, Lot No. B22-013-08.

No. 198, ID#BS071123A019, Grade A709M-345F2-X, Heat No. 07301431N0, MTR No. 6850,
Remarks-SPCM/Shell plate, Lot No. B22-010-08.

No. 199, ID#BS071123A017, Grade A709M-345F2-X, Heat No. 07301484N0, MTR No. 6853,
Remarks-SPCM, Lot No. B22-011-08.

No. 202, ID#WY070836Q110, Grade A709M-345F2-X, Heat No. 07301488N0, MTR No. 5986,
Remarks-SPCM/Shell plate, Lot No. B22-014-08.

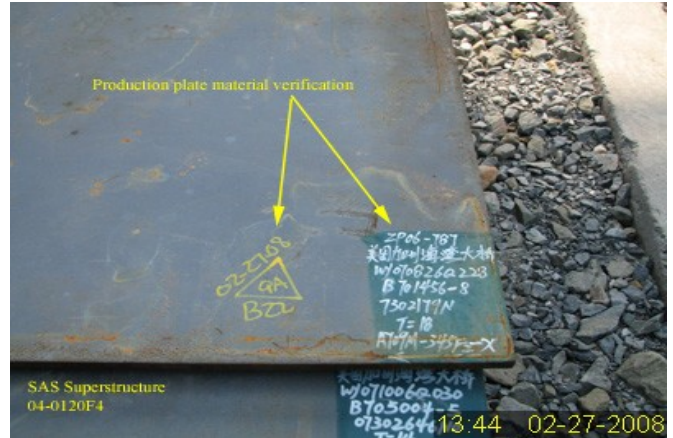
The above lot numbers were written on the each check sample along with an arrow showing the direction of rolling. The lot numbers, date, batch/heat numbers, plate type/grade and plate thickness were all entered on the

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Caltrans check sampling tracking log for Caltrans Project 04-0120F4. Note: Miss Weijuan informed QA Inspector Brannon that plate material for check sample No 194 and 196 for the 46th batch have not been located and should be found by tomorrow.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer